

Date: Wednesday, 16/07/2008 3:59:26 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: AFT FACING SEAT KIT	
Job Number	: 40573		Part Number	: D412769011	
Estimate Number	: 13464		Drawing Number	: IIN412-769 REV B	
P.O. Number	:		Project Number	: N/A	
This Issue	16/07/2008	S.O. No. :	Drawing Revision	: B	
Prsht Rev.	: NC		Material	:	
First Issue	/ /	Type	Due Date	: 10/08/2008	
Previous Run	:		Qty:	1 Um: Each	
Written By	:				
Checked & Approved By	: JUL08.7.16				
Comment	: Est rev A 08-07-17 new issue DD verified by:EC				

Additional Product

Jason,
 Please Cosign for
 QC 21 with
 Fr. days DATE
 Please
 Jm

Job Number:		
Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL 
JUL 08.8.13		
Comment:	DOCUMENT CONTROL Photocopy bluefile & type labels per PPP D412-769-011 CHG 001	
2.0	D412769041	Aft Facing Seat, LH 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Aft Facing Seat, LH batch: 40574		
3.0	D412769042	Aft Facing Seat, RH 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Aft Facing Seat, RH batch: B40575		
4.0	QC4	INSPECT 100% KITS FOR COMPLETENESS 
5.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP D412-769-011 Location: DETA PPP Rev: 8/8/15		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 16/07/2008 3:59:26 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT KIT

Job Number: 40573

Part Number: D412769011

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



08-08-15

08/08/19

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08/08/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4. WEIGHT AND BALANCE

The following is the weight increase associated with the D412-769-XXX Kits. The installer is responsible for the weight of the equipment coming out of the helicopter in order to install the D412-769-XXX Aft Facing Seat kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-769-011 Aft Facing Seat kit	60.0 lb 27.2 kg	0.0 in 0.0 m	0.00 in-lb 0.00 m-kg	87.0 in 2.21 m	5220 in-lb 60.11 m-kg
D412-769-041 Aft Facing Seat, LH (normal position)	30.0 lb 13.6 kg	-16.1 in -0.41 m	-483.0 in-lb -5.58 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-042 Aft Facing Seat, RH (normal position)	30.0 lb 13.6 kg	+16.1 in +0.41 m	+483.0 in-lb +5.58 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-041 Aft Facing Seat, LH (center position)	30.0 lb 13.6 kg	-1.1 in -0.03 m	-33.0 in-lb -0.41 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-042 Aft Facing Seat, RH (center position)	30.0 lb 13.6 kg	+1.1 in +0.03 m	+33.0 in-lb +0.41 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-041 Aft Facing Seat, LH (right Position)	30.0 lb 13.6 kg	+13.9 in +0.35 m	+417.0 in-lb +4.76 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-042 Aft Facing Seat, RH (left Position)	30.0 lb 13.6 kg	-13.9 in -0.35 m	-417.0 in-lb -4.76 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg

5. PARTS LIST

Qty -011	Qty -041	Qty -042	Part Number	Description
X			D412-769-011	AFT FACING SEAT KIT
1	X		D412-769-041	AFT FACING SEAT, LH
1		X	D412-769-042	AFT FACING SEAT, RH
1			D412-769-043	AFT FACING SEAT ASSEMBLY, LH
	1		D412-769-044	AFT FACING SEAT ASSEMBLY, RH
1	1		D412-724-041	HEAD REST ASSEMBLY, CENTER
1			D412-724-043	HEAD REST ASSEMBLY, LH
	1		D412-724-044	HEAD REST ASSEMBLY, RH

NO. 51507
WORK ORDER
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Revision: B
Date: 08.06.24

Date: Wednesday, 16/07/2008 3:59:30 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: AFT FACING SEAT, LH		
Job Number	: 40574			Part Number	: D412769041		
Estimate Number	: 13462			Drawing Number	: IIN412-769 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	16/07/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	/ /	Type	SMALL /MED FAB	Due Date	: 10/08/2008		
Previous Run	:			Qty:	1	Um:	Each
Written By	:						
Checked & Approved By	: <u>Jul 08.7.16</u>						
Comment	: Est rev A 08-07-17 new issue DD verified by:EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
Comment: DOCUMENT CONTROL Photocopy bluefile & type labels per PPP D412-769-041 CHG 001 <u>N/A</u>			
2.0	D412769043	Aft Facing Seat Assembly, LH	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Aft Facing Seat Assembly, LH batch: <u>401600</u> <u>88 08/08/15</u> <u>(X)</u>			
3.0	D412724041	Head Rest Assembly, Center	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Head Rest Assembly, Center batch: <u>40168</u> <u>50</u>			
4.0	D412724043	Head Rest Assembly, LH	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Head Rest Assembly, LH batch: <u>40498</u> <u>50</u> <u>81815</u> <u>30</u>			
5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS	
Comment: INSPECT 100% KITS FOR COMPLETENESS <u>Jul 08.15</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 16/07/2008 3:59:30 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT, LH

Job Number: 40574

Part Number: D412769041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	PACKAGING 1	PACKAGING RESOURCE #1
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(15)

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-769-041

Location:

PPP Rev: Draft

8/8/15

7.0	QC21	FINAL INSPECTION/W/O RELEASE
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208-08-15
08/08/19 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 08/08/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4. WEIGHT AND BALANCE

The following is the weight increase associated with the D412-769-XXX Kits. The installer is responsible for the weight of the equipment coming out of the helicopter in order to install the D412-769-XXX Aft Facing Seat kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-769-011	60.0 lb	0.0 in	0.00 in-lb	87.0 in	5220 in-lb
Aft Facing Seat kit	27.2 kg	0.0 m	0.00 m-kg	2.21 m	60.11 m-kg
D412-769-041	30.0 lb	-16.1 in	-483.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, LH (normal position)	13.6 kg	-0.41 m	-5.58 m-kg	2.21 m	30.06 m-kg
D412-769-042	30.0 lb	+16.1 in	+483.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, RH (normal position)	13.6 kg	+0.41 m	+5.58 m-kg	2.21 m	30.06 m-kg
D412-769-041	30.0 lb	-1.1 in	-33.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, LH (center position)	13.6 kg	-0.03 m	-0.41 m-kg	2.21 m	30.06 m-kg
D412-769-042	30.0 lb	+1.1 in	+33.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, RH (center position)	13.6 kg	+0.03 m	+0.41 m-kg	2.21 m	30.06 m-kg
D412-769-041	30.0 lb	+13.9 in	+417.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, LH (right Position)	13.6 kg	+0.35 m	+4.76 m-kg	2.21 m	30.06 m-kg
D412-769-042	30.0 lb	-13.9 in	-417.0 in-lb	87.0 in	2610 in-lb
Aft Facing Seat, RH (left Position)	13.6 kg	-0.35 m	-4.76 m-kg	2.21 m	30.06 m-kg

5. PARTS LIST

Qty -011	Qty -041	Qty -042	Part Number	Description
X			D412-769-011	AFT FACING SEAT KIT
1	X		D412-769-041	AFT FACING SEAT, LH
1		X	D412-769-042	AFT FACING SEAT, RH
1			D412-769-043	AFT FACING SEAT ASSEMBLY, LH
	1		D412-769-044	AFT FACING SEAT ASSEMBLY, RH
1	1		D412-724-041	HEAD REST ASSEMBLY, CENTER
1			D412-724-043	HEAD REST ASSEMBLY, LH
	1		D412-724-044	HEAD REST ASSEMBLY, RH

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WORK ORDER
NO. 10574

Date: Wednesday, 16/07/2008 3:59:34 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: AFT FACING SEAT, RH		
Job Number	: 40575			Part Number	: D412769042		
Estimate Number	: 13463			Drawing Number	: IIN412-769 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	16/07/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	:/	Type	SMALL /MED FAB	Due Date	10/08/2008	Qty:	1
Previous Run	:			Um:	Each		
Written By	:						
Checked & Approved By	: <u>JUL 08.7.16</u>						
Comment	: Est rev A 08-07-17 new issue DD verified by:EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
Comment: DOCUMENT CONTROL Photocopy bluefile & type labels per PPP D412-769-042 CHG 001 <i>N/A</i>			
2.0	D412769044	Aft Facing Seat Assembly, RH	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Aft Facing Seat Assembly, RH batch: <u>40001</u> <i>SP</i>			
3.0	D412724041	Head Rest Assembly, Center	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Head Rest Assembly, Center batch: <u>40168</u> <i>SP</i>			
4.0	D412724044	Head Rest Assembly, RH	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Head Rest Assembly, RH batch: <u>40169</u> <i>SP</i> <i>8/8/15</i>			
5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS	
Comment: INSPECT 100% KITS FOR COMPLETENESS			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 16/07/2008 3:59:34 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT, RH

Job Number: 40575

Part Number: D412769042

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	PACKAGING 1	PACKAGING RESOURCE #1 (QX)
		Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP D412-769-042 Location: <u>Draft</u> 8/8/15 PPP Rev: Sep 08-08-15
7.0	QC21	FINAL INSPECTION/W/O RELEASE 08/08/19

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08.08.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4. WEIGHT AND BALANCE

The following is the weight increase associated with the D412-769-XXX Kits. The installer is responsible for the weight of the equipment coming out of the helicopter in order to install the D412-769-XXX Aft Facing Seat kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-769-011 Aft Facing Seat kit	60.0 lb 27.2 kg	0.0 in 0.0 m	0.00 in-lb 0.00 m-kg	87.0 in 2.21 m	5220 in-lb 60.11 m-kg
D412-769-041 Aft Facing Seat, LH (normal position)	30.0 lb 13.6 kg	-16.1 in -0.41 m	-483.0 in-lb -5.58 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-042 Aft Facing Seat, RH (normal position)	30.0 lb 13.6 kg	+16.1 in +0.41 m	+483.0 in-lb +5.58 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-041 Aft Facing Seat, LH (center position)	30.0 lb 13.6 kg	-1.1 in -0.03 m	-33.0 in-lb -0.41 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-042 Aft Facing Seat, RH (center position)	30.0 lb 13.6 kg	+1.1 in +0.03 m	+33.0 in-lb +0.41 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-041 Aft Facing Seat, LH (right Position)	30.0 lb 13.6 kg	+13.9 in +0.35 m	+417.0 in-lb +4.76 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-042 Aft Facing Seat, RH (left Position)	30.0 lb 13.6 kg	-13.9 in -0.35 m	-417.0 in-lb -4.76 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg

5. PARTS LIST

Qty -011	Qty -041	Qty -042	Part Number	Description
X			D412-769-011	AFT FACING SEAT KIT
1	X		D412-769-041	AFT FACING SEAT, LH
1		X	D412-769-042	AFT FACING SEAT, RH
1			D412-769-043	AFT FACING SEAT ASSEMBLY, LH
	1		D412-769-044	AFT FACING SEAT ASSEMBLY, RH
1	1		D412-724-041	HEAD REST ASSEMBLY, CENTER
1			D412-724-043	HEAD REST ASSEMBLY, LH
	1		D412-724-044	HEAD REST ASSEMBLY, RH

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Revision: B
Date: 08.06.24

Date: Friday, 15/08/2008 2:30:26 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: REPLACEMENT WINDOW KIT		
Job Number	: 41259		Part Number	: D350567113		
Estimate Number	: 12349		Drawing Number	: N/A		
P.O. Number	:		Project Number	: N/A		
This Issue	: 15/08/2008		Drawing Revision	: N/A		
Prsht Rev.	: NC		Material	:		
First Issue	: / /		Due Date	: 22/08/2008		Qty: 1 Um: Each
Previous Run	: 41099A					
Written By	:					
Checked & Approved By	:					
Comment	: Est Rev:A 04-08-24 New Issue JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL  Comment: Photocopy bluefile & type labels per PPPD350-567-113
2.0	PACKAGING 1	PACKAGING RESOURCE #1  Comment: PACKAGING RESOURCE #1 Pick Packing Kit ***ENSURE DT 8439 TEMPLATE IS INCLUDED***
3.0	D2463	Seal  Comment: Qty.: 7.5243 f(s)/Unit Total : 7.5243 f(s) 1/2" Seal 86.6" Long Batch: 38677
4.0	D3290041	Replacement Window Assembly  Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Replacement Window Assy Batch: 39870
5.0	21212	Receptacles  Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s) Receptacles Batch: 107203

Date: Friday, 15/08/2008 2:30:26 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REPLACEMENT WINDOW KIT

Job Number: 41259

Part Number: D350567113

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 26006 Camlock Stud



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Camlock Stud

Batch: 108606

AS 08/08/15 (X1)

7.0 2600LW Camloc Retaining Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Camloc Retaining Washer

Batch: M107600 x 4 M108607 x 8

AS 08/08/15 (X5)

8.0 AN526C832R9 Screw



Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s)

Screw

Batch: M108377

AS 08/08/15 (X2)

9.0 AN960JD8 Washer



Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s)

Washer

Batch: M107650

AS 08/08/15 (X2)

10.0 MS20426AD34 RIVET



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

RIVET

Batch: M105978

AS 08/08/15 (X5)

11.0 MS21042L08 Nut



Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s)

Nut

Batch: M107990

AS 08/08/15 (X1)

12.0 FG778150550ROL 7781 9oz Glass 50"x125yd



Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

2sq yd of 7781 9oz Glass 50"x125yd

Batch: 104845

AS 08/08/15 (X2)

Date: Friday, 15/08/2008 2:30:26 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REPLACEMENT WINDOW KIT

Job Number: 41259

Part Number: D350567113

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



108-08-15 D



Comment: INSPECT 100% KITS FOR COMPLETENESS

14.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-567-113

Location: _____

PPP Rev: _____

Rev C

AS 08/08/13
108-08-15
08/08/13
08/08/13

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08-08-15